

Work Order ID 85968

85968

Page 1

Item ID: D2344

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/19

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2344	Rev F

100	FLOW WATER JET	0.00				10	0		JM 12-6-23
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100
Waterjet
FLOW CNC Waterjet
~~2034~~ ~~0133~~

Memo
1-Cut as per dwg
prog rev: F
dwg rev: F
2-deburr as required

110	QC2- Inspect parts off machine FAI/FAIB	0.00				10	0		JM 12-6-23
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110
QC
Quality Control

Memo

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 85968

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June-19-12 11:56:54 AM

Item ID: D2344

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N900040100

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Revision ID:

Stop ***NS2***

Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012 Start Qty: 10.00

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Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

10 12/06/24

130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges 2-Countersink holes per Dwg D2344

10 12/06/24

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

5/12/06/24

(40)

Dart Aerospace Ltd

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June-19-12 11:56:54 AM

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Setup Start ***NS1***

Revision ID:

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Stop ***NS2***

Start Date: 19/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

10 12-6-27

155 QC7-Inspect Chemical Conversion Coat

0.00

155

QC

Memo

0.00

Quality Control

10X 12/07/03

160 Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

160

Powdercoat

Memo

Powder Coating

START TIME:

8-15

OVEN TEMPERATURE:

FINISH TIME:

8-45

3200F

10X 12/07/03

12/27/09

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Work Order ID 85968

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June-19-12 11:56:55 AM

Item ID: D2344

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N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Litter Deck Plate, 350

Start Date: 19/06/2012 Start Qty: 10.00

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Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

170 QC3- Inspect Part Finish

0.00

170

QC Memo

0.00

Quality Control

10 6 12-7-3

180 Identify as per dwg & Stock Location: *85224* 0.00

180

Packaging Memo

0.00

Packaging

102 80 12-7-3

190 QC21- Final Inspection - Work Order Release 0.00

190

QC Memo

0.00

Quality Control

12/7/4

MF 12-07-03

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NOTE: Date & initial all entries

Picklist Print

June-19-12 11:56:58 AM

Work Order ID: 85968

Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350

85968

D2344

Page 1

Start Date: 19/06/2012

Required Date: 03/07/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:D00.06.26Removed P/O for powder coatEC
IPP Rev:E 07-07-04 Asper Rev F JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

268.9700

0.745

7.842105

M2024T3S 063

**

2024-T3 .063 sheet

Jm 12-6-23

Location

Loc Qty

Loc Code

MAT022

268.97

119916

73.27

121197

195.7

121197

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DART AEROSPACE LTD		Work Order:	85968
Description: Litter Deck Plate Kit (350)		Part Number:	D2344
Inspection Dwg: D2344	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.224"	✓		✓	mmoi
5.598	+/-0.010	5.604"	✓		✓	mmoi
4.869	+/-0.010	4.876"	✓		✓	mmoi
3.889	+/-0.010	3.896"	✓		✓	mmoi
3.096	+/-0.010	3.100"	✓		✓	mmoi
2.891	+/-0.010	2.894	✓		✓	mmoi
16.973	+/-0.010	16.973"	✓		mt	HB01
0.450	+/-0.010	0.454"	✓		✓	mmoi
4.423	+/-0.010	4.423"	✓		✓	mmoi
4.723	+/-0.010	4.721"	✓		✓	mmoi
1.202	+/-0.010	1.198"	✓		✓	mmoi
5.869	+/-0.010	5.870"	✓		✓	mmoi
4.654	+/-0.010	4.660"	✓		✓	mmoi
Ø0.656	+0.005/-0.000	0.656"	✓		✓	mmoi
1.888	+/-0.010	1.891"	✓		✓	mmoi
2.285	+/-0.010	2.286"	✓		✓	mmoi
2.683	+/-0.010	2.687	✓		✓	mmoi
Ø0.171	+0.005/-0.000	0.172"	✓		✓	mmoi
3.491	+/-0.010	3.495"	✓		✓	mmoi
Ø0.191	+0.005/-0.000	0.192"	✓		✓	mmoi
3.123	+/-0.010	3.130"	✓		✓	mmoi
1.975	+/-0.010	1.982"	✓		✓	mmoi
Ø0.128	+0.005/-0.001	0.129"	✓		✓	mmoi

Measured by: JM	Audited by: M/W	Prototype Approval:	N/A
Date: 12-6-23	Date: 12-6-24	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	JE

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